

# 內徑車刀識別系統

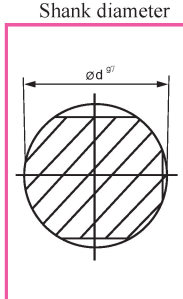
Boring Bar Identification System

## S 32 S E C L N R 12

- 1 刀柄材質/樣式 Construction features/Type
- 2 刀柄直徑 Shank diameter
- 3 柄長 Shank length
- 4 夾持方式 Clamping system
- 5 刀片形狀 Insert shape
- 6 切刀形狀記號 Toolholder shape
- 7 離隙角 Relief angle
- 8 進刀變換 Version
- 9 切邊長度 Cutting edge length

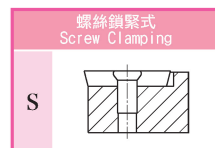
- 1 刀柄材質/樣式 Construction features/Type    2 刀柄直徑 Shank diameter    3 柄長 Shank length(mm)

| 記號<br>Sign | 材質及樣式 Construction features/Type     |
|------------|--------------------------------------|
| S          | 鋼 Steel                              |
| A          | 鋼 Steel(w) : 刀柄中心出水 Thru coolant     |
| D          | 防震刀架 Devibrator                      |
| C          | 鎢鋼 Carbide                           |
| E          | 鎢鋼 Carbide (w) : 刀柄中心出水 Thru coolant |
| H          | 模具鋼 Alloy tool steel                 |
| R          | 迴轉刀頭 Rotating head                   |



| 記號<br>Sign | 長度<br>Length | 記號<br>Sign | 長度<br>Length |
|------------|--------------|------------|--------------|
| H          | 100          | T          | 300          |
| J          | 110          | U          | 350          |
| K          | 125          | V          | 400          |
| M          | 150          | W          | 450          |
| Q          | 180          | Y          | 500          |
| R          | 200          | X          | Special      |
| S          | 250          |            |              |

- 4 夾持方式 Clamping system



- 5 刀片形狀 Insert shape

| 記號<br>Sign | 刀片形狀<br>Insert shape | 角度<br>Angle |
|------------|----------------------|-------------|
| C          |                      | 80°         |
| D          |                      | 55°         |
| V          |                      | 35°         |
| K          |                      | 55°         |
| S          |                      | 90°         |
| T          |                      | 60°         |
| W          |                      | 80°         |

- 6 切刀形狀記號 Toolholder Shape

| 記號<br>Sign | 切入角度<br>Toolholder shape |
|------------|--------------------------|
| L          |                          |
| U          |                          |
| F          |                          |
| K          |                          |
| Z          |                          |
| Q          |                          |

- 7 離隙角 Relief Angle

| 記號<br>Sign | 離隙角<br>Relief Angle |
|------------|---------------------|
| B          |                     |
| C          |                     |
| N          |                     |
| P          |                     |

- 8 進刀變換 Version

| 記號<br>Sign | 方向<br>Direction |
|------------|-----------------|
| R          |                 |
| L          |                 |

- 9 切邊長度 Cutting Edge Length

| 記號<br>Sign | 切邊長度<br>Cutting Edge Length |
|------------|-----------------------------|
| R          |                             |
| S          |                             |
| T          |                             |
| W          |                             |
| A,B,K      |                             |
| C,D,E,M,V  |                             |
| L          |                             |

A  
刀片  
INSERT

B  
鎢鋼端銑刀  
CARBIDE END MILL

C  
外徑車刀架  
TOOL HOLDER

D  
外徑出水車刀架  
TOOL HOLDER WITH COOLANT

E  
走心式車刀架  
AUTOMATIC LATHES

F  
手工具  
HAND TOOLS

G  
內徑車刀架  
BORING BAR

H  
切斷刀架  
GROOVING

I  
銑刀  
END MILL CUTTER

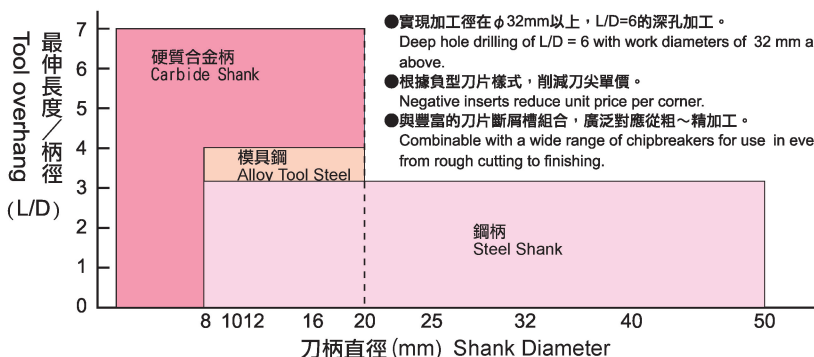
J  
快速鑽頭  
RAPID DRILL

K  
機床配件  
MACHINE ACCESSORIES

## 內徑刀柄型式 Steel / carbide shank applications

| 記號 Sign | 材質及樣式<br>Construction features/Type                | 樣式圖解 |
|---------|----------------------------------------------------|------|
| A       | 鋼柄中心出水式<br>Steel Shank With Oil Hole               |      |
| C       | 鎢鋼刀柄<br>Carbide Shank                              |      |
| S       | 一般鋼刀柄<br>Steel Shank                               |      |
| H       | 模具鋼刀柄<br>Alloy Tool Steel                          |      |
| -O      | 模具鋼刀柄中心出水式<br>Alloy Tool Steel Shank With Oil Hole |      |

## 按刀桿尺寸分的推薦使用領域 Application range by shank type



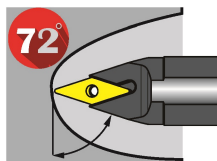
切削速度 Cutting Speed  $V_c=20\sim 200\text{m/min}$   
切 深 Depth-of-cut  $a_p=0.1\sim 2.0\text{mm}$   
進 給 量 Feed Rate  $f=0.1\sim 0.3\text{mm/rev}$

※根據被削材、刀具形狀、加工條件等，可實際加工的突出量發生了變化。  
※Actual amount of overhang may differ according to work material, tool shape, and machining conditions.

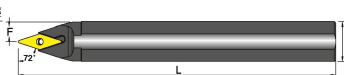
## 刀桿材質選定 Shank Material Selection

| 加工方法 Application                                      | 鏜刀種 Type                        | 鋼刀桿<br>Steel Shank             | 模具鋼<br>Alloy Tool Steel | 硬質合金刀桿<br>Carbide Shank |
|-------------------------------------------------------|---------------------------------|--------------------------------|-------------------------|-------------------------|
| 一般鋼<br>General Steel                                  | 淺孔加工 ( $L/D < 3$ ) Shallow Hole | ◎ (經濟性)<br>◎ (More economical) |                         |                         |
|                                                       | 深孔加工 ( $L/D < 3$ ) Deep Hole    |                                |                         | ◎                       |
| 模具鋼<br>Alloy Tool Steel                               | 深孔加工 ( $L/D < 4$ ) Deep Hole    |                                |                         |                         |
| 利用修光刀片的高效加工<br>High efficiency boring by wiper insert |                                 |                                | ◎                       | ◎                       |
| 淬火鋼，高硬度材的加工 Hardened Steel                            |                                 |                                |                         | ◎                       |
| 高精度加工 High precision boring                           |                                 |                                |                         | ◎                       |

# SVVBN



ØB最小加工徑



本圖所示為右手刀(R)  
Right-Hand Show

| 產品型號 Model No | 材質<br>Shank | 在庫<br>Stock | 加工徑<br>Min. Bore Dia. | 寸法 Dimension(mm) |    |     |    |  | 刀片<br>Insert<br> | 零件 Parts                                                                                         |                                                                                                     | 價格<br>Price |
|---------------|-------------|-------------|-----------------------|------------------|----|-----|----|--|---------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------|-------------|
|               |             |             | ØB                    | D                | F  | L   | K  |  |                                                                                                   | 螺絲<br>Screw<br> | 旗型板手<br>Wrench<br> |             |
| S32S-SVVBN16  | S           | ●           | 33                    | 32               | 16 | 250 | 10 |  | VB□□1604□□                                                                                        | CS35                                                                                             | T-15                                                                                                |             |
| S40T-SVVBN16  |             | ●           | 42                    | 40               | 20 | 300 | 0  |  |                                                                                                   |                                                                                                  |                                                                                                     |             |

●刀片資料：VB□□1604□□→參考AK頁

●Insert Detail：VB□□1604□□→Ref. Page-AK

●套筒可另購→參考278~283頁 ●Sleeve refer Page-278~283

G  
內徑車刀架  
BORING BAR

